

Date: Tuesday, 12/20/2005 9:44:55 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206B BASKET BASE
Job Number : 22087B	
Estimate Number : 11276	
P.O. Number : N/A	Part Number : D2330041
This Issue : 12/20/2005 S.O. No. : N/A	Drawing Number : UNDER REVIEW
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LARGE FAB ASSY	Drawing Revision : E
Previous Run :	Material : N/A
Written By : <u>SEE COMMENT BELOW</u>	Due Date : 1/30/2006 Qty: 1 Um: Each
Checked & Approved By : <u>SEE ABOVE USER & DATE</u>	
Comment : Est Rev:H 02.09.04 M304EX0.75-16F was M750-16FXS-S/S K J	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D31661	Basket Hoop
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part#	Description	Batch
4	D3166-1	Hoop	BABAS9 (2) B25849 (2) PD 06-04-05

2.0	M304TS0750W065	304 SQ Tube.75x.75x.065W
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Comment: Qty.: 25.3019 f(s)/Unit Total : 25.3019 f(s)

3/4" x 3/4" x 0.063 wall 304/316 SS tubing. Batch: M100S60 PD 06-04-05

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Cut Rib from 3/4" x 3/4" x 0.063 wall 304/316 SS tubing.

Cut 4 D2235-1 From D3166-1

2- Cut D2330-1-3-5-7-9 as per Dwg D2330

3-Drill hole in D2330-3 as per Dwg D2330

4-Deburr PD 06-04-05

4.0	D22531	Lug
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2253	Gusset	B12413 PD 06-04-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/20/2005 9:44:56 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B BASKET BASE

Job Number: 22087B

Part Number: D2330041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	D2012107	Clevis
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
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1	D2012-107	Clevis	
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~~B25483~~ B25483

PD

06-04-05

6.0	D23273	Spacer Bushing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
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1	D2327-3	Bushing	
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B25323

PD

06-04-05

7.0	D2581	Mounting Bracket
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
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4	D2581	Mounting Chancel	
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B25834(3) B26204(1)

PD

06-04-05

8.0	D2254	Gusset for D206bskt
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
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2	D2254	Lug	
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B23421

PD

06-04-05

9.0	D22323	Basket Hinge
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
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2	D2232-3	HINGE	
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B25239

PD

06-04-05

10.0	D2012107	Clevis
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
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1	D2012-107	CLEVIS	
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~~B25483~~ B25483

PD

06-04-05

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: SD Date: 06/04/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/20/2005 9:44:56 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B BASKET BASE

Job Number: 22087B

Part Number: D2330041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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11.0	M304EX07516F	Expanded Metal Flat Stai
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Comment: Qty.: 31.5000 sf(s)/Unit Total : 31.5000 sf(s)

Pick:

Qty	Part Number	Description	Batch
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30 sf	M304EX0.75-16F	Expanded Metal	M100513
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PD

06-04-11

12.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2330 using Welding Table and corner JigDeburr as required

A/R SS ROD Batch: M19555

PD

06-04-11

13.0	QC5/9	WELD INSPECTION
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Comment: WELD INSPECTION

NA 06/04/11

14.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DC 06/04/13 ①

15.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06 09 13 ①

16.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

N/A

17.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21

① 06/04/20

Job Completion



06.04.20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5104

DART AEROSPACE LTD	Work Order:	22087
Description: 206B Basket Base	Part Number:	D2330-041
Drawing: D2330 Rev. ^{D1} Pages 1,3,4 & 5	Qty:	1

R04.06.23

Step	Location	Procedure	By	Date	Qty																												
1	DC	Open Traveller Dwg not required	JA	04.12.14	1																												
2	WS	Cut Rib from 3/4" x 3/4" x 0.063 wall 304/316 SS tubing. Batch: _____ Cut Qty. 4 D2235-1 from: Qty. 4 D3166-1 Batch: _____																															
3	WS	Drill hole in D2330-3 as per Dwg D2330																															
4	WS	Deburr																															
5	WS RF 02/07/10	Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>2</td><td>D2253-1</td><td>Gusset</td><td>_____</td></tr><tr><td>1</td><td>D2012-107</td><td>Clevis</td><td>_____</td></tr><tr><td>1</td><td>D2327-3</td><td>Bushing</td><td>_____</td></tr><tr><td>4</td><td>D2581</td><td>Mounting Chancel</td><td>_____</td></tr><tr><td>2</td><td>D2254</td><td>Lug</td><td>_____</td></tr><tr><td>30 sf</td><td>M304EX0.75-16F</td><td>Expanded Metal</td><td>_____</td></tr></table>	Qty	Part Number	Description	Batch	2	D2253-1	Gusset	_____	1	D2012-107	Clevis	_____	1	D2327-3	Bushing	_____	4	D2581	Mounting Chancel	_____	2	D2254	Lug	_____	30 sf	M304EX0.75-16F	Expanded Metal	_____			
Qty	Part Number	Description	Batch																														
2	D2253-1	Gusset	_____																														
1	D2012-107	Clevis	_____																														
1	D2327-3	Bushing	_____																														
4	D2581	Mounting Chancel	_____																														
2	D2254	Lug	_____																														
30 sf	M304EX0.75-16F	Expanded Metal	_____																														
6	WS	Weld as per Dwg D2330 using Welding Table and corner Jig Deburr as required																															
7	QC9 & 6	Inspect Welding and Dimensions																															
8	WS	Take Traveller D206-540-013 to KP																															
9	FP	Powder Coat White (Ref. 4.3.5.2) as per QSI 005 4.3																															
10	QC3	Inspect Powder Coat																															
11	FP	To Miscellaneous Cell for Assembly																															

Rev	Date	Change	Revised By	Approved
B	94.12.03	/		JB
C	99.09.17	Re-format (was lpp-341B)	EC	
D	99.12.14	Re-format, Added Clevis to pick list	EC	
E	00.02.03	Re-format, Added Rib to pick list	EC	
F	00.06.26	Removed P/O for powder coat	EC	
G	02.07.23	Re-format added D3166-1; Modify Step 1	KJ	
H	02.09.04	M304EX0.75-16F was M750-16FXS-S/S	KJ RF	<i>[Signature]</i>

RELEASED
02/09/09 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____